

Date:  
User:Thursday, 3/13/2008 10:25:19 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAFING SHIELD
Job Number	: 37969		
Estimate Number	: 11138		
P.O. Number	:	Part Number	: D31901
This Issue	: 3/13/2008 S.O. No. :	Drawing Number	: D3190 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 37343	Material	:
Written By	:	Due Date	: 3/19/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>H 08 03 13</u>		
Comment	: Est. A 03.05.26 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S25GA 304/316 .020" Sheet



Comment: Qty.: 0.2261 sf(s)/Unit Total : 4.5213 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet

~~(M304S25GA)~~ M304S266A Batch: M107021

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

Handwritten notes: B08/03/17 20, mf 08-03-17 (20)

Arrow pointing from 'Grind corner' to 'B08/03/17'.

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 19W

Handwritten notes: 8/3/18, SCP, (20x)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Handwritten notes: mi 2008/3/18, (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 01/03/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

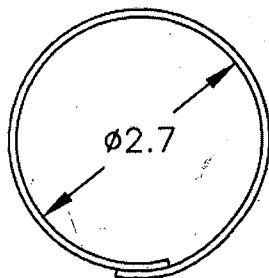
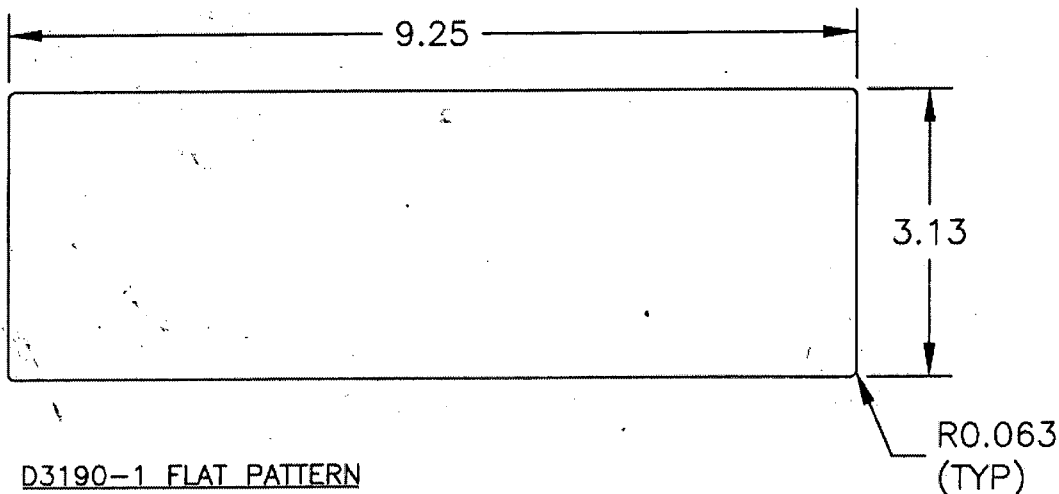
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY UP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED  
03.05.22 #



D3190-1 ROLLING DETAIL  
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC. M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37969

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.